

Date: Wednesday, 04/10/2006 2:21:07 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RING	
Job Number	: 28856				
Estimate Number	: 10608				
P.O. Number	: N/A		Part Number	: D2655	
This Issue	04/10/2006	S.O. No.	S.O. No.	: D2655 REV B	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B	
Previous Run	: 28856		Material	: N/A	
Written By			Due Date	: 25/10/2006 Qty: 20 Um: Each	
Checked & Approved By					
Comment	: Est. D 00.06.22 Removed P/O for powder-coat EC Est Rev:E Now on Waterjet 06-10-04 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1018B400X250	Inventory
		 Comment: Qty.: 0.2835 f(s)/Unit Total : 5.6700 f(s) 1018 ASTM A36 .250" thk bar x 4.0" Batch: M1018B400X250 06/06/05
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D2655 Dwg Rev: B 06/06/05 Prog Rev: B
		 Comment: FLOW WATER JET 1-Cut as per Dwg D2655 Dwg Rev: B 06/06/05 Prog Rev: B
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Tumble - .030 Radius 2-Deburr any rough edges after tumbling



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 28856

Part Number: D2655

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



*Job 10-10 (10)*

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat per QSI 005 4.3.5.1

*a.m 06/10/11 (11)*

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST140

*06/10/12 (11)*

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*DP 06/10/12 (11)*

Job Completion



*W 06/10/12*

Date: Tuesday, 10/3/2006 3:47:31 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RING		
Job Number	: 28856		Part Number	: D2655		
Estimate Number	: 10608		Drawing Number	: D2655 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 10/3/2006	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: PURCHASED PARTS			
Previous Run	: 27110		Due Date	: 10/28/2006		Qty: 20 Um: Each
Written By	:		<i>10/06 1003</i>			
Checked & Approved By	:					
Comment	: Est. D 06.06.22 Removed P/O for powder coat EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING  <i>150x411 1018</i> <i>.710 feet</i> <i>W2 Kryet</i>
2.0	D2655F	Ring 
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s) Ring
3.0	PACKAGING 1	PACKAGING RESOURCE #1 
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK 
		Comment: DIMENSIONAL CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Tumble - .030 Radius 2-Deburr any rough edges after tumbling

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 3:47:31 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 28856

Part Number: D2655

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat per QSI 005 4.3.5.1

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

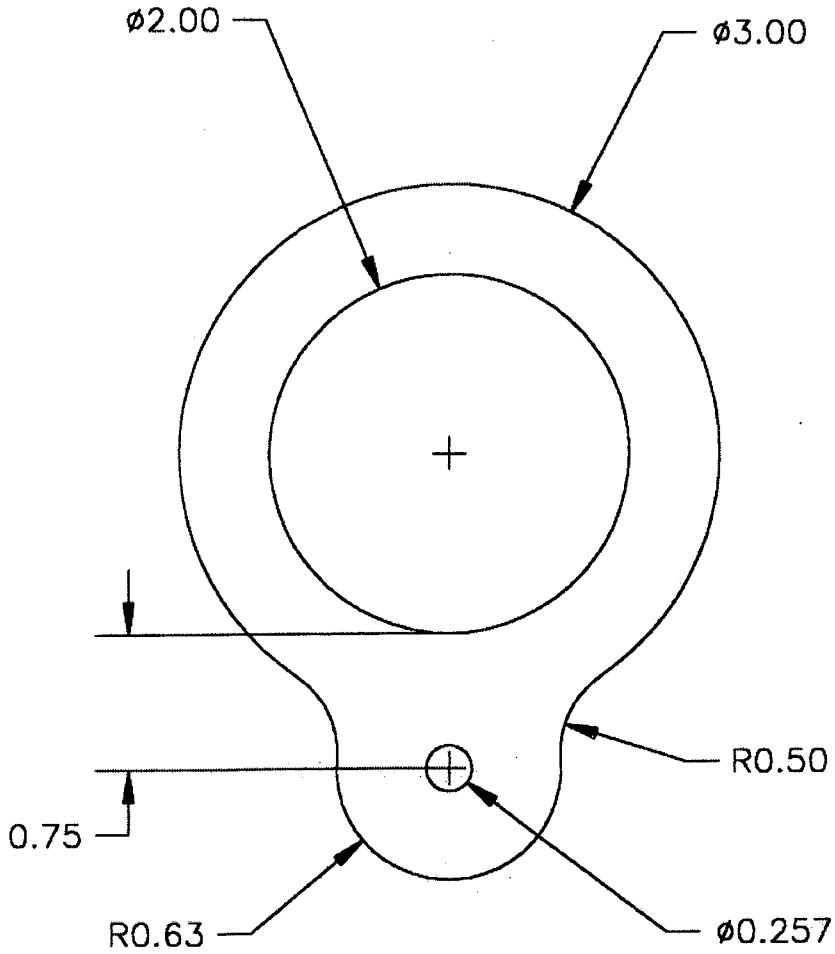
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

**DART**

COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED	APPROVED	DRAWING NO. D2655
DATE		REV. B SHEET 1 OF 1
97:07:07		TITLE RING
		SCALE 1:1
A	97:03:25	NEW ISSUE
B	97:07:07	ADD ASTM A36 TO MAT. SPEC.

**RELEASED**  
47/07/97 DS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
28856  
NO.

NOTE: DEBURR ALL SHARP EDGES

MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK

FINISH: POWDER COAT PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD	Work Order:	28856
Description: Ring	Part Number:	32655
Inspection Dwg: 2655 Rev: B		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## **X First Article      X Prototype**

Measured by:	<i>M. M</i>	Audited by:	<i>J</i>	Prototype Approval:	<i>N/A</i>
Date:	<i>26/10/05</i>	Date:	<i>26/10/05</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	